

Date: Monday, 2/19/2007 8:08:06 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PIN
Job Number	: 30759			
Estimate Number	: 12672			
P.O. Number	: N/A		Part Number	: D31471
This Issue	: 2/19/2007 S.O. No. : N/A		Drawing Number	: D3147 REV C
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: C
Previous Run	: 30694		Material	: N/A
Written By			Due Date	: 2/26/2007 Qty: 6 Um: Each
Checked & Approved By				
Comment	: Est Rev A New Issue 07-01-26 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0187	303 Round Bar 0.187"
	Comment: Qty.: 0.2363 f(s)/Unit Total : 1.4175 f(s) 303 Round Bar 0.187" Batch: M103435	MS 07/02/19
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: 1-TURN AS PER FOLIO FA113 & DWG D3147 , FOLIO REV: _____ DWG REV: _____	3 done manually MS 07/02/19
	2-DEBURR AS REQUIRED	MS 07/02/19
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MS 07/02/19
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE Drill & mill as per Dwg D3147	JF 07-02-20
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JF 07-02-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 30759		Part Number: D31471
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		 2/02/20 (6)
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 5		 2/02/20 (8) (6)
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 2/02/22 (6)
Job Completion		 2/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

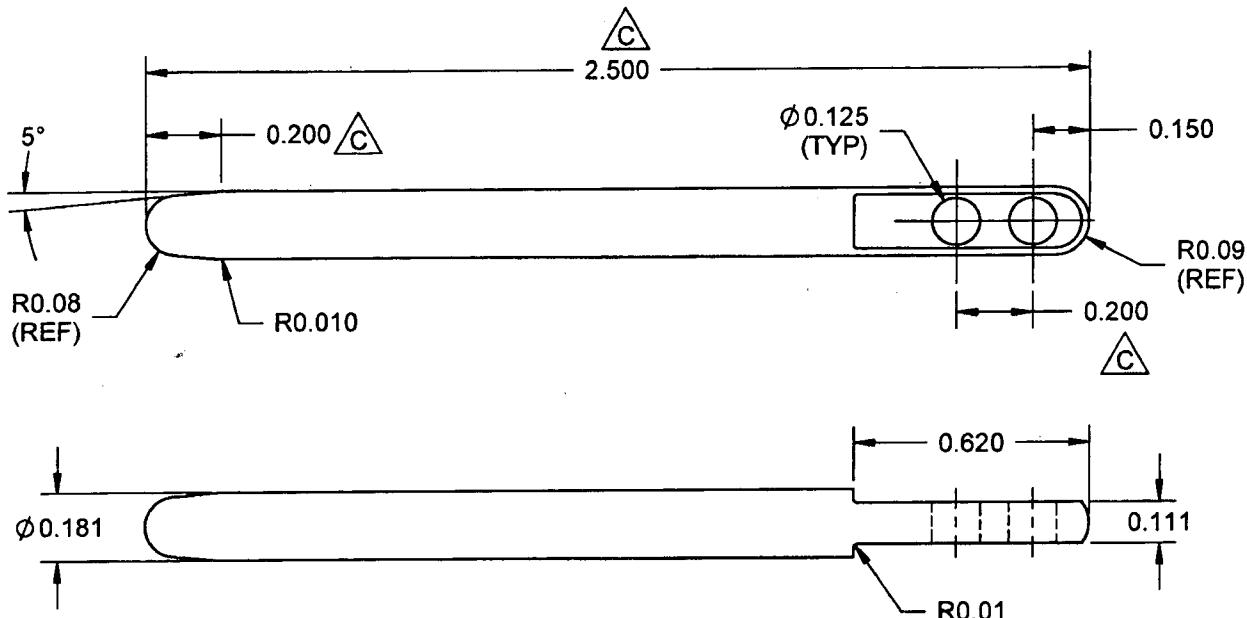
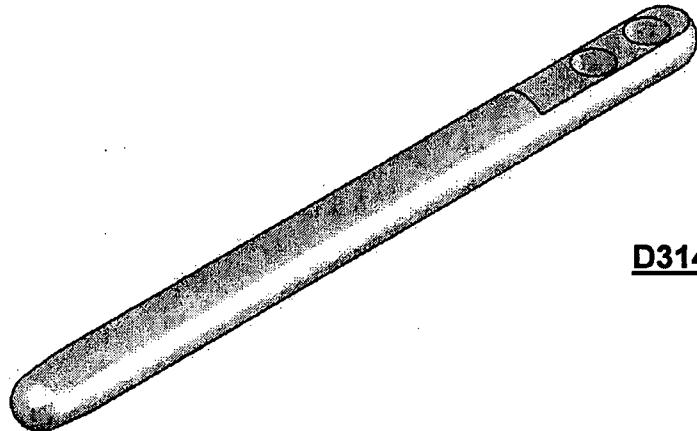
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>AF</i>	DRAWN BY <i>JLH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>AF</i>	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04	TITLE PIN	SCALE 2:1	

REV	DATE	DESCRIPTION
A	02.04.23	NEW ISSUE
B	04.10.18	ADD PART MARKING AND NORMALIZED
C	06.12.04	ADD SECOND Ø 0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING

**D3147-1 PIN****RELEASED**07-01-22 *[Signature]***NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30759

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DART AEROSPACE LTD	Work Order:	30759
Description: Pin	Part Number:	D3147-1
Inspection Dwg: D3147 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	M&J/Jewell
Date:	07/02/19

Audited by:	<i>[Signature]</i>
Date:	07-02-20

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	